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(54) **Method and unit for packaging and palletizing rolls of toilet paper and/or kitchen towel**

Vorrichtung und Verfahren zur Verpackung und Palletisierung von Toiletten- und/oder
Küchenpapierrollen

Unité et procédé d'emballage et de palletisation du rouleaux de papier hygienique et/ou de papier de
cuisine

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Description

[0001] The present invention relates to a unit and to a method for packaging and palletizing rolls of toilet paper and/or kitchen towel.

[0002] Rolls of toilet paper and/or kitchen towel, packaged according to various configurations, are called loose packages and in particular cases or packs depending on the different arrangement of the rolls in several layers or rows. A plurality of loose packages can then be packaged in a bagging machine according to various configurations forming a so-called bag.

[0003] In fact, the use of bagging machines to associate the rolls of paper, already packaged in multiple units (loose packages) in a single package called bag, is already known.

[0004] In so-called robotized palletizing stations or areas, one or two manipulators provided with grippers are used to form pallets which can be composed of superimposed layers comprising a plurality of bags or comprising a plurality of packages of multiple units.

[0005] In a packaging line for rolls of toilet paper and/or kitchen towels, according to specific needs pallets comprising layers or bags or loose packages can be composed on each occasion in the same palletizing area.

[0006] The line is composed of a bagging machine, fed with the loose packages, which provides bags of the previously chosen format, and a conveyor belt, or feeding line dedicated to the loose packages, which can also be loaded manually.

[0007] To manage the flow of bags or loose packages arriving from the two feed lines, an additional device, or sorting station, must be provided for this purpose upstream of the palletizing area, to divide the multiple units of rolls or the bags into several rows and orient them in order to form partial collections ready to be subsequently picked up by the robot positioned to form a complete layer of pallets.

[0008] From the description, this technical solution seems bulky as it requires the presence of several dedicated conveyor belts and a specific orientation device. Moreover, this solution is consequently costly both from the viewpoint of costs to supply the individual machines and running costs.

[0009] The object of the present invention is to produce a compact unit for packaging and palletizing rolls of toilet paper and/or kitchen towels composed of a small number of devices.

[0010] Another object of the present invention is to produce a unit which produces layers of pallets with high stability.

[0011] A further object is to produce a unit which packages both loose packages and bags and wherein the operating mode can be changed very quickly.

[0012] Yet another object of the present invention is to produce a simple and functional unit and a method for packaging and palletizing rolls of toilet paper and/or kitchen towels with moderate costs.

[0013] These objects according to the present invention are achieved by producing a unit and method for packaging and palletizing rolls of toilet paper and/or kitchen towels as set forth in the independent claims.

[0014] Further characteristics of the unit and of the method are provided in the dependent claims.

[0015] The characteristics and advantages of a unit and a method for packaging and palletizing rolls of toilet paper and/or kitchen towels according to the present invention shall become more apparent from the following exemplary and non-limiting description with reference to the appended schematic drawings, wherein:

Figure 1 shows a schematic plan view of a unit for packaging and palletizing rolls of toilet paper and/or kitchen towels according to the present invention; Figure 2 shows an example of a loose package comprising two rolls of kitchen towel;

Figure 3 shows an example of a sequence of batches delivered from the bagging and/or forming machine, wherein the batches differ from one another and are composed of a variable number of loose packages in Figure 2;

Figure 4 shows a schematic plan view of an example of a layer of pallets composed with one of the two rows of batches in Figure 3;

Figure 5 shows an example of a batch of products wrapped in a bag.

[0016] With reference to the figures, a unit for packaging and palletizing rolls of toilet paper and/or kitchen towels is shown, indicated as a whole with 10 and comprising a bagging and/or forming machine 20 and a palletizing station 30 positioned in series with each other and connected by means of a conveyor element 21, such as a conveyor belt, to form a single production unit.

[0017] Packages of multiple units of rolls, or loose packages 11, are fed to the bagging and/or forming machine 20, shown purely as an example in Figure 2, where two rolls of kitchen towel packaged side by side are shown. By carrying out a specific work programme for each type of pallet to be produced, the bagging machine 20 sorts the loose packages 11 according to batches 12 of products, wherein the batches have continuously variable forms and dimensions.

[0018] The bagging machine 20 can optionally unload the batches 12 of sorted loose packages as shown in figure 3 onto the conveyor belt 21, or can form a so-called bag 13, shown schematically by way of an example in Figure 5, by wrapping the batch of sorted loose packages in a plastic containment film 14 and then unloading said bag 13, which forms a batch 12 of bagged product, onto the conveyor belt 21.

[0019] The bagging and/or forming machine 20 supplies the batches 12 to the station downstream in one or more rows, with a predetermined stepped sequence and spaced from one another to be handled in the palletizing station 30.

[0020] In fact, this station 30 comprises at least one robot or manipulator 31 provided with grippers to handle the batches 12 of products, both when they are composed of a plurality of loose packages and when they are constituted by a bag 13.

[0021] In the unit 10, shown schematically in Figure 1, the bagging machine 20 supplies, for example, two rows of batches of products 12 to the same number of robots 31, each suitable to grip, orient and position the batches 12 of products, whether loose packages 11 or bagged 13, to form a layer 15 of the pallet.

[0022] The robots 31 and the bagging and/or forming machine 20 constitute a single unit operating in one block, as they are electronically interconnected with each other and are programmed to sort and optionally to bag, and to handle the batches 12 of products, loose packages or bags, of different form and dimensions according to a continuously variable sequence in a predetermined and programmable way.

[0023] In fact, the sorted batches 12 delivered from the bagging machine 20 can be composed of a different and programmed number of loose packages 11 which, appropriately handled by the robot 31 downstream, can be disposed adjacent to and engaged with one another, to occupy the entire surface of each layer 15 and give stability to the pallet 16 composed of superimposed layers. Figure 3 shows an example in a plan view of a sequence of batches 12 delivered from the bagging and/or forming machine 20, wherein the batches are composed of a variable number of loose packages 11 of the type shown in Figure 2, and wherein the batches 12 of each box marked with dashed lines are used to form a layer 15 as shown in Figure 4.

The layers 15 formed by the pair of robots 31 are picked up by a further robot 32, positioned downstream as shown schematically in Figure 1, which stacks them on a pallet base 17 or on the other layers 15 previously formed to form a complete pallet 16.

Each layer 15 consists of a certain number of batches of products, loose packages or bags, of different forms and dimensions, which are disposed engaged with one another as shown for example in Figure 4 in order to cover the entire surface of the layer of pallets. Compared with a layer composed of adjacent batches the same as one another, the layer produced with the unit and method according to the present invention offers greater stability to the completed pallet.

In the preferred embodiment of the unit for packaging and palletizing rolls of toilet paper and/or kitchen towel 10, disclosed in the present invention, in which the bagging and/or forming machine supplies two rows of sorted batches to two gripping robots 31, in the case of a fault or production requirements the unit can also operate when fed with only one row of batches.

In particular, the unit for packaging and palletizing rolls of toilet paper and/or kitchen towel 10, disclosed in the present invention, provides a method for packaging and palletizing rolls of toilet paper and/or kitchen towel char-

acterized by the steps of feeding the rolls of toilet paper and/or kitchen towel packaged in multiple units, or loose packages 11, to the bagging and/or forming machine 20 and sorting the loose packages 11 in said machine into batches 12 of products with continuously variable forms and dimensions according to a predetermined and programmable sequence.

The loose packages sorted into batches in the bagging and/or sorting machine can be subjected to a further packaging step consisting in wrapping them in a bag 13, or else they can be unloaded directly on the conveyor belt 21.

This is followed by the step of feeding the sorted batches 12 towards the palletizing station 30 using the conveyor element 21 on which they are disposed along at least one row, with a predetermined stepped sequence and spaced from one another, as well as the step to pick up the batches 12 of product by means of one or more robots or manipulators 31 to form the layer 15 of batches, adjacent to and engaged with one another.

Finally, the layer 15 of batches of products is picked up by the further manipulator 32 and stacked on the pallet base 17 or on other layers 15 formed previously to form the complete pallet 16.

The unit for packaging and palletizing rolls of toilet paper and/or kitchen towel has the advantage of reducing the number of the conveyor elements for connection between the individual machines, resulting in a more compact final part of the production line.

Moreover, besides reducing the costs, the unit according to the present invention also has the advantage of reducing the noise of the production line as well as the number of personnel required.

Furthermore, with the method for packaging and palletizing rolls of toilet paper and/or kitchen towel according to the present invention, complete pallets with high stability are advantageously produced.

Claims

1. Unit for packaging and palletizing rolls of toilet paper and/or kitchen towel **characterized in that** it comprises a bagging and/or forming machine (20), suitable to sort several packages containing a plurality of rolls, called loose packages (11), into batches (12), and optionally to bag said sorted loose packages (11) in a bag (13) made of a plastic material, and a palletizing station or area (30) comprising at least one robot or manipulator (31) provided with grippers to handle batches (12) of sorted products composed of loose packages (11) or of a bag (13), wherein said batches (12) delivered from said bagging and/or forming machine (20) are conveyed to said palletizing station (30) with a predetermined stepped sequence and spaced from one another in at least one row on a conveyer element (21), wherein said at least one robot (31) and said bagging and/or

forming machine (20) are electronically interconnected and are programmed respectively to sort and handle said products in batches (12), loose packages (11) or bags (13), of different forms and dimensions according to a sequence, continuously variable in a predetermined and programmable way, to form a layer (15) of a pallet (16) with different batches (12) of products adjacent to and engaged with one another.

2. Unit as claimed in claim 1, **characterized in that** said batches (12), loose packages (11) or bags (13), delivered from said bagging machine (20) are conveyed to said palletizing station (30) along two spaced rows, said palletizing station (30) comprising two robots (31), each suitable to pick up the batches (12) of products from one row.
3. Unit as claimed in claim 1, **characterized in that** it comprises downstream of the at least one robot (31) to pick up the batches (12) of products, a further picking-up robot (32) which picks up said layer (15) and stacks it on a pallet base (17) or on other layers (15) to form a pallet (16).
4. Method for packaging and palletizing rolls of toilet paper and/or kitchen towel **characterized in that** it comprises the steps of feeding said rolls of toilet paper and/or kitchen towel packaged in multiple units, called loose packages (11), to a bagging and/or sorting machine (20), sorting said loose packages (11) into batches (12) of products with continuously variable forms and dimensions according to a predetermined and programmable sequence, feeding said batches (12) with a stepped sequence on a conveyor element (21) in at least one row to a palletizing station (30), picking up said batches (12) of products using a robot or manipulator (31) and forming a layer (15) of batches, adjacent to and engaged with one another.
5. Method as claimed in claim 4, **characterized in that** in said bagging machine (20) said loose packages (11) sorted into batches of products are packaged in a bag (13).
6. Method as claimed in claim 4, **characterized in that** said layer (15) of batches of products is picked up by a further manipulator (32) and stacked on a pallet base (17) or on other layers (15) to form a pallet (16).

Patentansprüche

1. Vorrichtung zum Verpacken und Palletieren von Toiletten- und/oder Küchenpapierrollen, **dadurch gekennzeichnet, dass** sie eine Einsack- und/oder Formgebungsmaschine (20), welche geeignet ist,

mehrere Pakkungen, die mehrere Rollen enthalten, so genannte Losepackungen (11), in Stapel (12) zu sortieren, und optional die sortierten Losepackungen (11) in einen aus Kunststoffmaterial gefertigten Sack (13) einzusacken, und eine Palletierstation oder einen Palletierbereich (30), welche/welcher mindestens einen Roboter oder Manipulator (31), welcher mit Greifern zum Handhaben von Stapeln (12) von sortierten Produkten, die aus Losepackungen (11) oder aus einem Sack (13) gebildet sind, aufweist, umfasst, wobei die Stapel (12), welche von der Einsack- und/oder Formgebungsmaschine (20) geliefert werden, zu der Palletierstation (30) mit einer vorbestimmten gestuften Abfolge und voneinander beabstandet in mindestens einer Reihe auf einem Förderbandeinsatz (21) befördert werden, wobei der mindestens eine Roboter (31) und die Einsack- und/oder Formgebungsmaschine (20) elektronisch verbunden sind bzw. programmiert sind, um die Produkte in Stapeln (12), Losepackungen (11) oder Säcken (13) von unterschiedlichen Formen und Abmessungen gemäß einer Abfolge kontinuierlich veränderlich in einer vorbestimmten und programmierbaren Art und Weise zu sortieren und zu handhaben, um eine Schicht (15) einer Palette (16) mit unterschiedlichen Stapeln (12) von Produkten miteinander benachbart und in Eingriff befindlich auszubilden.

2. Vorrichtung nach Anspruch 1, **dadurch gekennzeichnet, dass** die Stapel (12), Losepackungen (11) oder Säcke (13), welche von der Einsackmaschine (20) geliefert werden, entlang zwei beabstandeter Reihen zu der Palletierstation (30) befördert werden, wobei die Palletierstation (30) zwei Roboter (31), welche jeweils geeignet sind, die Stapel (12) der Produkte von einer Reihe aufzunehmen, umfasst.
3. Vorrichtung nach Anspruch 1, **dadurch gekennzeichnet, dass** sie dem mindestens einen Roboter (31) zum Aufnehmen der Stapel (12) von Produkten nachgelagert einen weiteren aufnehmenden Roboter (32) aufweist, welcher die Schichten (15) aufnimmt und sie auf einer Palettenbasis (17) oder auf anderen Schichten (15) stapelt, um eine Palette (16) auszubilden.
4. Verfahren zum Verpacken und Palletieren von Toiletten- und/oder Küchenpapierrollen, **dadurch gekennzeichnet, dass** es die Schritte des Zuführens der Toiletten- und/oder Küchenpapierrollen, welche in Mehrfacheinheiten, so genannten Losepackungen (11), verpackt sind zu einer Einsack- und/oder Sortiermaschine (20), Sortierens der Losepackungen (11) in Stapel (12) von Produkten mit kontinuierlich veränderlichen Formen und Abmessungen gemäß einem vorbestimmten und programmierbaren Ablauf,

Zuführens der Stapel (12) in mindestens einer Zeile zu einer Palletierstation (30) mit einer gestuften Abfolge auf einem Förderbandeinsetz (21),
 Aufnehmens der Stapel (12) von Produkten unter Verwendung eines Roboters oder Manipulators (31) und
 Ausbildens einer Schicht (15) von Stapeln, welche miteinander benachbart und in Eingriff befindlich sind,
 umfasst.

5. Verfahren nach Anspruch 4, **dadurch gekennzeichnet, dass** die Losepackungen (11), welche in Stapel von Produkten sortiert sind, in der Einsackmaschine (20) in einen Sack (13) verpackt werden.
6. Verfahren nach Anspruch 4, **dadurch gekennzeichnet, dass** die Schicht (15) von Stapeln von Produkten von einem weiteren Manipulator (32) aufgenommen wird und auf eine Palettenbasis (17) oder auf andere Schichten (15) gestapelt wird, um eine Palette (16) auszubilden.

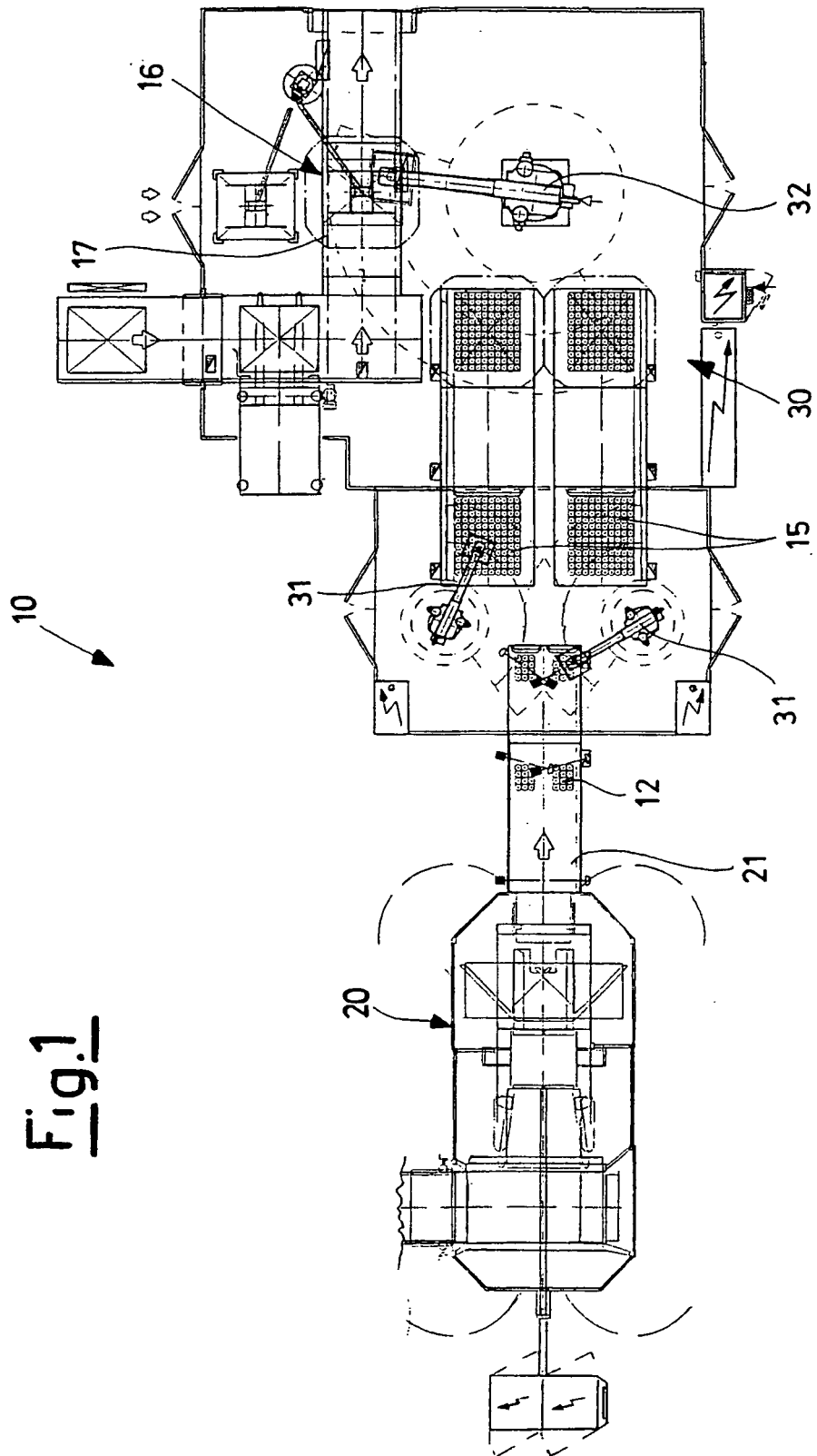
Revendications

1. Unité d'emballage et de palettisation de rouleaux de papier hygiénique et/ou de papier essuie-tout **caractérisée en ce qu'elle** comprend une machine d'ensachage et/ou de formage (20), appropriée pour trier plusieurs emballages contenant une pluralité de rouleaux, appelés emballages en vrac (11), dans des lots (12), et en option d'ensacher lesdits emballages en vrac (11) dans un sac (13) fait de matière plastique, et une station ou zone de palettisation (30) comprenant au moins un robot ou manipulateur (31) pourvu de pinces pour manipuler les lots (12) de produits triés composés d'emballages en vrac (11) ou d'un sac (13), dans laquelle lesdits lots (12) amenés depuis ladite machine d'ensachage et/ou de formage (20) sont transportés vers ladite station de palettisation (30) avec une séquence progressive prédéterminée et espacés l'un de l'autre dans au moins une rangée sur un élément convoyeur (21), dans laquelle ledit au moins un robot (31) et ladite machine d'ensachage et/ou de formage (20) sont électroniquement interconnectés et sont programmés respectivement pour trier et manipuler lesdits produits dans des lots (12), emballages en vrac (11) ou sacs (13), de différentes formes et dimensions selon une séquence, continuellement variable d'une façon prédéterminée et programmable, pour former une couche (15) d'une palette (16) avec différents lots (12) de produits adjacents à et en prise les uns avec les autres.
2. Unité selon la revendication 1, **caractérisée en ce que** lesdits lots (12), emballages en vrac (11) ou

sacs (13), amenés depuis ladite machine d'ensachage (20) sont transportés à ladite station de palettisation (30) le long de deux rangées espacées, ladite station de palettisation (30) comprenant deux robots (31), chacun étant approprié pour prélever les lots (12) de produits depuis une rangée.

3. Unité selon la revendication 1, **caractérisée en ce qu'elle** comprend en aval de l'au moins un robot (31) pour prélever les lots (12) de produits, un autre robot de prélèvement (32) qui prélève ladite couche (15) et l'empile sur une base de palette (17) ou sur d'autres couches (15) pour former une palette (16).
4. Procédé d'emballage et de palettisation de rouleaux de papier hygiénique et/ou de papier essuie-tout **caractérisé en ce qu'il** comprend les étapes consistant à avancer lesdits rouleaux de papier hygiénique et/ou de papier essuie-tout emballés en unités multiples, appelées emballages en vrac (11), vers une machine d'ensachage et/ou de tri (20), trier lesdits emballages en vrac (11) en lots (12) de produits avec des formes et dimensions continuellement variables selon une séquence prédéterminée et programmable, avancer lesdits lots (12) avec une séquence progressive sur un élément convoyeur (21) dans au moins une rangée vers une station de palettisation (30), prélever lesdits lots (12) de produits en utilisant un robot ou manipulateur (31) et former une couche (15) de lots, adjacents à et venant en prise les uns avec les autres.
5. Procédé selon la revendication 4, **caractérisé en ce que** dans ladite machine d'ensachage (20) lesdits emballages en vrac (11) triés en lots de produits sont emballés dans un sac (13).
6. Procédé selon la revendication 4, **caractérisé en ce que** ladite couche (15) de lots de produits est prélevée par un autre manipulateur (32) et empilée sur une base de palette (17) ou sur d'autres couches (15) pour former une palette (16).

Fig. 1



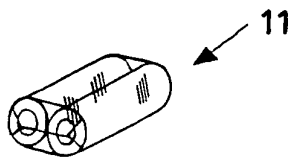


Fig. 2

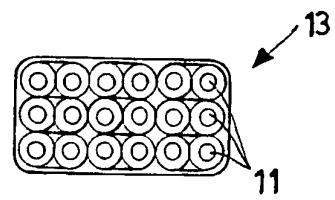


Fig. 5

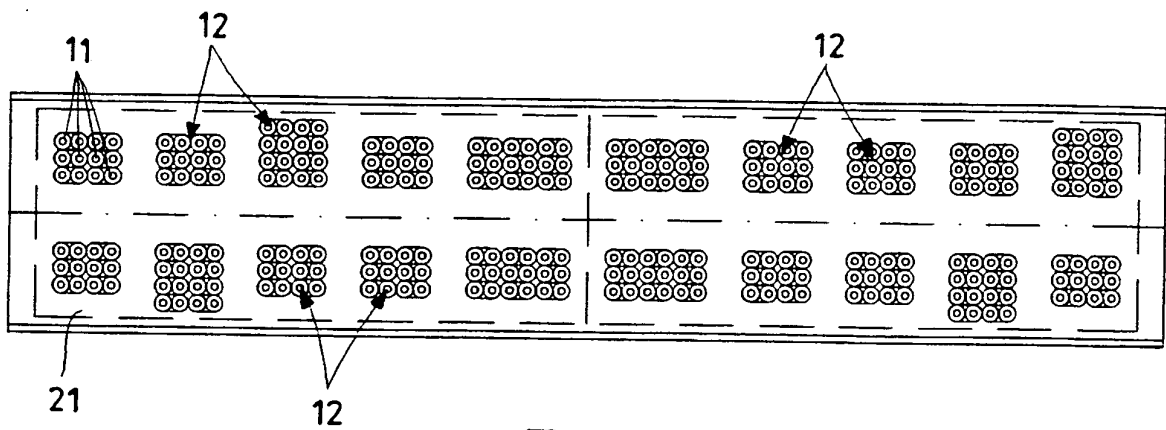


Fig. 3

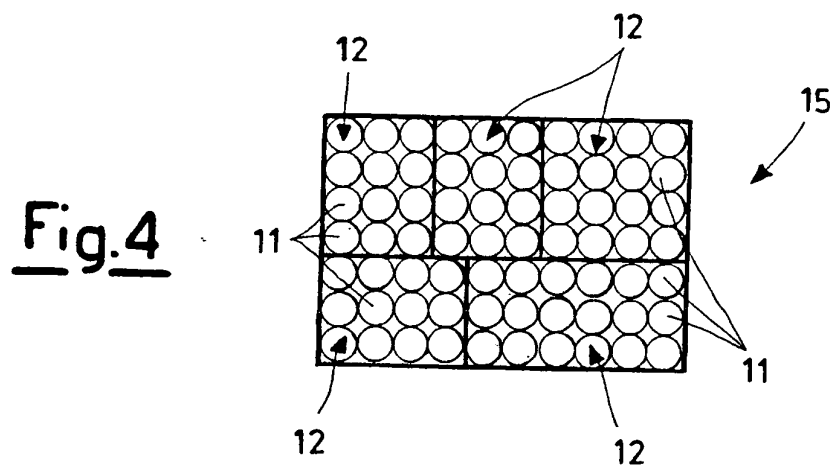


Fig. 4